



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5504-1
Job Sheet 196938



Part No: D5504-1

Job Qty: 16 pcs

Part Name: Blade



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/25/19

Job Tracking No:

Due Date: 7/5/19 *July 20*

Created By: Kimberley Guerin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Bandsaw - 1	16 pcs	7/5/19	7/5/19	0.00	0.80	Bandsaw - 1	<i>mmc 19/06/19</i>
110	HAAS 4 Axis - B4B	16 pcs	7/5/19	7/5/19	1.00	16.00	HAAS - 1 - B4B	<i>mmc 19/06/19</i>
							HAAS - 2 - B4B	
							HAAS - 3 - B4B	
							HAAS - 4 - B4B	
120	QC 2	16 pcs	7/5/19	7/5/19	0.00	0.00	QC 2 - 1	<i>mmc 19/06/19</i>
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	



Container No: S194922



Part: D5504-1

Job No: 196938

Serial No/Batch: S194922

Revision:

Inspector:

Exp Date:

Instructions:

Date: 06/29/19

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

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					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
130	QC 8	16 pcs	7/5/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	ML 19/07/02
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
140	Outsource - 1 - Heat Treat	16 pcs	7/5/19		MEI001-VC	10 KH 2019-07-03
150	Packaging 2-1 - Receive - B4B	16 pcs	7/5/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	OP JUL 18 2019
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	

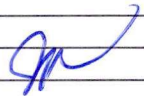
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					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
155 QC 6	16 pcs	7/5/19	0.00 0.00	QC 6 - 9		
				QC 6 - 68		
				QC 6 - 61		
				QC 6 - 40		
160 Spray Paint - 2 - B4B	16 pcs	7/5/19	0.00 4.00	Spray Paint - 1 - B4B		
				Spray Paint - 2 - B4B		
				Spray Paint - 3 - B4B		
				Spray Paint - 4 - B4B		
170 QC 14	16 pcs	7/5/19	0.00 0.00	QC 14 - 15		
				QC 14 - 2		
				QC 14 - 34		
				QC 14 - 41		
				QC 14 - 51		
				QC 14 - 58		
				QC 14 - 59		
				QC 14 - 9		
				QC 14 - 68		
				QC 14 - 40		
				QC 14 - 19		
				QC 14 - 43		
				QC 14 - 24		
				QC 14 - 61		
				QC 14 - 81		
180 Packaging 3-1 - Stock - B4B	16 pcs	7/5/19	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		

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PC CLK BT

				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	16 pcs	7/5/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - Bandsaw - Cut Blank at 3.900"

Descriptions: 110 - HAAS CNC Vertical Machine - 1-Machine per folio FB553 DWG REV: A FOLIO REV: AA 2-
 Deburr and break all sharp edges EXCEPT OTHERWISE NOTED. SEE NOTE 8 ***KNIFE EDGE MUST BE
 SHARPENED USING STONE, REMOVE ALL BURRS ON CUTTING EDGE***

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

140 - PO to Metcor: FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2
 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED PO: 043899

150 - Receive & Inspect for Damage & Mat'l Certs

155 - QC6- All purchased or subcontracted products

160 - Spray Paint / NDT Room - PRIME AS PER DWG AND QSI005, SEE NOTE #2 PRIME AS PER IAW MIL-P-23377J
 TYPE 1 CLASS N ***1-2 MIL MAX*** PRIMER BATCH: 5195271

170 - QC14- Inspect Spray Paint

180 - Identify as per dwg & Stock Location: _____

190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MSTEEL-A2-B0.500X1.250	AISI A2 Tool Steel Bar, 0.500 X 1.250	5.2000 ft (.325 ea)	100-Bandsaw - 1	<u>5172910</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	MSTEEL-A2-B0.500X1.250	5	25	0

Part Specifications

Specifications could not be found.

Plex 6/25/19 3:59 PM Dart.Guerin.Kimberley

MAT
 USED
 5.2000'

11/00/80
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Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043899



Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

Attention: Bejenaru, Livia

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043899

PO Date: 7/3/19

Due Date: 7/19/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
2019-07-04

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	197082	RB T102137- 101-105	Pin 1-Issue P/O; RC 48-52 2-Bead blast 3-Material type; Q1 4- Certificate of Conformity is required	Firmed -		7/9/19	8 pcs	0 pcs	8 pcs	\$79.875/pcs	\$639.00
8x JUL 09 2019											
2	196938	D5504-1	Blade PO to Metcor: FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED	Firmed -		7/19/19	16 pcs	0 pcs	16 pcs	\$19.375/pcs	\$310.00
K16 JUL 18 2019											

Grand Total: \$949.00

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PURCHASE ORDER

POHB043899



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/18/19 11:54 AM Dart.paul.derick

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
337773	1	138642

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À /Shipped To

DART AEROSPACE

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
HB043899		A2	2019/7/3	CLIENT

QUANTITÉ Quantity	No. PIÈCE / Part No.	NOM DE LA PIÈCE / Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
16	D5504-1			4,
	(16) D5504-1			
	JOB. 196938			
	1 BC EPS			

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
BC EPS	1	

CERTIFICAT

EXPÉDIÉ PAR: Shipped by:	
-----------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 16
POIDS EXPÉDIÉ / Weight Shipped : 4,00
QUANTITÉ RESTANTE / Quantity Remaining : 0
POIDS RESTANT / Weight Remaining : 0,00

RECEIVED

JUL 17 2019

DART AEROSPACE LTD.

APPROUVÉ
[Signature]

CERTIFICAT

QUANTITÉ EXPÉDIÉE / Quantity Shipped:	16
POIDS EXPÉDIÉ / Weight Shipped :	4,00

Signature:

Date:

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
337773	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
HB043899	N/A	A2		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications				
VAC HARDEN				DAS 40 9-89
HARDEN AND TEMPER				
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results	
HARDNESS	58 - 62 HRC	5 (907)	58 - 59 HRC	
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
16	4	D5504-1 (16) D5504-1 JOB. 196938 1 BC EPS		

COMMENTAIRES / comments

VAC HARDEN 1800°F - 1:40 HRS
DOUBLE TEMPER 400°F - 2:00 HRS

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

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Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

Ce document et les documents qui lui sont joints peuvent contenir des informations confidentielles, être soumis aux réglementations relatives au contrôle des exportations ou ayant un caractère privé. S'ils ne vous sont pas destinés, nous

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

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Télécopieur / Fax administration: 450-491-5498

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Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
337773	1

CLIENT / customer 215

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ON K6A 1K7

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APPROUVÉ par / Approved by:

DATE: 2019-07-11

Lucie Desmarais
QA Technician



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METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

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Télécopieur / Fax production: 450 491-6454

Certificat de Conformité

Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
337773	1

CLIENT / customer 215

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HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
HB043899	N/A	A2		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

VAC HARDEN

HARDEN AND TEMPER

DAS
40
9-89

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	58 - 62 HRC	5 (907)	58 - 59 HRC

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
16	4	D5504-1 (16) D5504-1 JOB. 196938 1 BC EPS

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

DATE: 2019-07-10

Pierre Piché
Chief Inspector

METCOR
6

APPROUVÉ